

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024006**Date Inspected:** 17-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 001/003, Located on Bike path Hand rails, FS1. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Zhang Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 002, Located on Bike path Hand rails, FS2. Welder is identified as 068918. ZPMC Quality Control Inspector (QC) is identified as Zhang Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 003, Located on Bike path Hand rails, FS2-P41. Welder is identified as 201985. ZPMC Quality Control Inspector (QC) is identified as Zhang Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

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Witness of Ultrasonic Testing (UT)

This QA inspector Witnessed 100% UT performed by ZPMC Quality Control personnel. The member is identified as OBG, Cap plate Component. The component and weld designation identified as follows:

X3744A-001-001

X3744A-002-001

X3744A-003-001

X3744A-004-001

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as OBG Crash Barrier Component. The component and weld designation identified as follows:

W5-SB31-006 – 019, 026, 126, 127

E2-SB25B-002 – 081, 127, 128, 129,130

E2-SB25D-002 – 019,050, 081, 129,130, 131

Bay #19

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- X64BC as per CWR no. B-CWR-2877, Located on Suspender Bracket SB 022-108E. Welder is identified as 062811. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –Repair.

Repair welding of Weld joint- X64A as per CWR no. B-CWR-2877, Located on Suspender Bracket SB 023-106E. Welder is identified as 259966. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –Repair.

Repair welding of Weld joint- X64B as per CWR no. B-CWR-2877, Located on Suspender Bracket SB 022-106W. Welder is identified as 259906. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –Repair.

For further information see below pictures:-

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan
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Quality Assurance Inspector

Reviewed By:	Clifford, William
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QA Reviewer
